

Work Order ID 91959

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October-19-12 2:49:32 PM

Item ID: D350-591-312

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop *NS2*

Start Date: 10/19/12 Start Qty: 10.00 *10*

Cust Item ID:

Required Date: 11/09/12 Req'd Qty: 10.00 *10*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				(13)	12-11-12		DAS 09 2-09
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				10			DAS 15 2-09
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				10	21112	12-11-12	

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Item ID: D350-591-312

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop

NS2

Start Date: 10/19/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/09/12 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC Inspect Part Finish	0.00				10	0		D4 235 89
150									
QC	Memo	0.00							
Quality Control									
180		0.00							
180	Large Fab					10	0		Ac 12.11.15 P 12.11.15 Ac 12.11.15
Large Fab	Memo	0.00							
Large Fab	1-Assemble Leg Assembly as per Dwg D3272.								
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/RAluminum Rod 122358								
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg.								

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Item ID: D350-591-312 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step, Long RH
 Start Date: 10/19/12 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 11/09/12 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							(15) 12-11-16 
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							(15) 12-11-16 
210 *210* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							10X  12/11/16

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Item ID: D350-591-312

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N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop ***NS2***

Start Date: 10/19/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/09/12 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
220									
Powdercoat									
Powder Coating									
	Memo								
	START TIME: 3:40	0.00							
	OVEN TEMPERATURE: 320 °F								
	FINISH TIME: 4:10								
230	Wing Walk as per dwg QSI005 4.4 Batch 122878	0.00							
230									
HandFinish									
Hand Finishing									
	Memo								
240	QC3- Inspect Part Finish	0.00							
240									
QC									
Quality Control									
	Memo								

W122878

10 X 8
RH
12/11/19

DH 12/11/20

AS
15
12-11-20

10

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Item ID: D350-591-312

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N900040100

Setup Start *NS1*

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop *NS2*

Start Date: 10/19/12 **Start Qty:** 10.00

10

Cust Item ID:**Required Date:** 11/09/12 **Req'd Qty:** 10.00

10

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

270

Packaging

0.00

270

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312

Location: HALL Room

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Item ID: D350-591-312

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop ***NS2***

Start Date: 10/19/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/09/12 Req'd Qty: 10.00

10

Customer:

Reference:


Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

12/11/22 
MF
12-11-22

Picklist Print

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Page 1

Work Order ID: 91959

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 10/19/12

Required Date: 11/09/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A04.03.22New issue KJ/RF
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D fixe route seq in bom DD
 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1 Step		Manufactured	No			110	Each	20.0000	1	10		12.10.31	

Location	Loc Qty	Loc Code
ST	-10	
WA 892140 →	30	
86573	5	
91756	10	
91757	5	

10X

D3067-1
End Plate

Manufactured No

110 Each 226.0000

1 10

12.10.08

Location	Loc Qty	Loc Code
WA	222	
78608	4	
83855	1	
90177	15	
90178	22	
90335	60	
90336	60	
90486	60	
WA016	4	
67582	2	
68214	1	
79607	1	

10

Picklist Print

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Page 2

Work Order ID: 91959

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 10/19/12

Required Date: 11/09/12

Start Qty: 10.00

Required Qty: 10.00

D3219-1 Manufactured No
Plate

110 Each 274.0000 2 20

12.11.08

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	256	
88888	12	
89966	108	
<u>89967</u>	108	<i>20</i>
90704	28	
WA016	18	
73410	12	
77674	6	

D3066-1 Manufactured No
Spacer

180 Each 179.0000 2 20

12.11.15

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	179	
90211	30	
<u>90212</u>	60	<i>(14)</i>
<u>90346</u>	29	<i>(6)</i>
90347	60	

MS20600-AD4W4 Purchased No
Rivets

180 Each 1,578.0000 16 160

12.11.15

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
321	18	
121652	18	
ST311	1000	
<u>123021</u>	1000	<i>(160)</i>
ST321	560	
121011	9	
121340	39	
121444	512	

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Shop Packet Print

Page 2

Picklist Print

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Work Order ID: 91959

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 10/19/12

Required Date: 11/09/12

Start Qty: 10.00

Required Qty: 10.00

D3065-041 Manufactured No

180 Each 21.0000 1 10

B90012 (X10)
Ac 12.11.15

Location	Loc Qty	Loc Code
ST	-30	
WA	21	
66149	0	
79336	1	
88822	5	
90011	15	
WA013	30	

D3067-1 Manufactured No

180 Each 226.0000 1 10

12.11.15

Location	Loc Qty	Loc Code
WA	222	
78608	4	
83855	1	
90177	15	
90178	22	
90335	60	
90336	60	
90486	60	
WA016	4	
67582	2	
68214	1	
79607	1	

D30350 Purchased No

250 Each 190.0000 2 20

SP12-11-21

Location	Loc Qty	Loc Code
FG	10	
122800	10	
ST353	180	
123352	180	

20x

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Picklist Print

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Work Order ID: 91959

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 10/19/12

Required Date: 11/09/12

Start Qty: 10.00

Required Qty: 10.00

D3235-1 Manufactured No

Mounting Lug

Sms 10x

Location

250 Each 126.0000

20

SP

2

ST470

Loc Qty

Loc Code

126

90002

126

D3278-041 Manufactured No

Support Assembly

Sms 10x

AN960JD416

NAS1149D0463J

Purchased No

Washer

Sms 10x

Location

Loc Qty

Loc Code

ST351

29

116289

8

119097

21

AN960JD516 Purchased No

Washer

NAS1149D0563J

Sms 10x

Location

Loc Qty

Loc Code

ST338

2

1069059

2

ANS-36A Purchased No

Bolt

Sms 10x

Location

Loc Qty

Loc Code

ST338

46

123021

46

D2618 Manufactured No

Bushing

Sms 10x

Location

Loc Qty

Loc Code

ST013

5

76130

2

84646

3

250 Each 5.0000

20

2

SP 12-11-20

2

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Shop Packet Print

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Picklist Print

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Page 5

Work Order ID: 91959

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 10/19/12

Required Date: 11/09/12

Start Qty: 10.00

Required Qty: 10.00

D2230-3 Manufactured No
Lug

250 Each 316.0000

B89082.3x.
B92287.34x.
8

Sm
107

Location	Loc Qty	Loc Code
FG	1	
89045	1	
ST469	315	
89782	19	
89950	200	
90514	96	

D2856-400 Manufactured No
Abrasion Strip

250 f 409.2539

2x
12
SP 12-11-20.
8

Sm *107*

Location	Loc Qty	Loc Code
ST403	120.2525	
81875	6.398	
<u>89352</u>	113.8545	
ST408	216	
90764	216	
ST409	73.0014	
63735	0.6696	
68076	0.3149	
71164	8.46	
86905	63.5569	

12x

Picklist Print

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Work Order ID: 91959

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 10/19/12

Required Date: 11/09/12

Start Qty: 10.00

Required Qty: 10.00

MS2104213

Purchased

No

250

Each

3,340.0000

2

20

Nut

Location

Loc Qty

Loc Code

316 651
122452 651
ST300 338
117885 32
119017 168
119075 138
ST314 1831
123265 1831
ST317 520
122141 520

Smb 107

AN3-13A

Bolt

Purchased

No

250

Each

1,002.0000

8

80

Location

Loc Qty

Loc Code

ST356 809
122416 287
122808 22
122993 500
ST357 193
120187 19
120770 12
121652 161
122063 1

Smb 107

m123525 sp
12-11-20-

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Picklist Print

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Page 7

Work Order ID: 91959

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 10/19/12

Required Date: 11/09/12

Start Qty: 10.00

Required Qty: 10.00

MS21042L5

Purchased

No

250

Each

1,253.0000

2

20

SP.

Nut

SMS 10x

Location

Loc Qty

Loc Code

300

173

121652

173

314

1000

122452

1000

20x

ST300

80

108827

4

116105

1

116548

43

119109

20

2937

12

MS21042L4

Purchased

No

250

Each

5,326.0000

8

80

SP.

Nut

SMS 10x

Location

Loc Qty

Loc Code

314

1399

122452

1399

ST300

27

119017

20

121444

7

ST314

3900

123021

3000

80

123248

900

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

4

40

17122378

Washer

SMS 10x

SP 12-11-20.

October-19-12 2:49:32 PM

Shop Packet Print

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DESIGN <i>GP</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

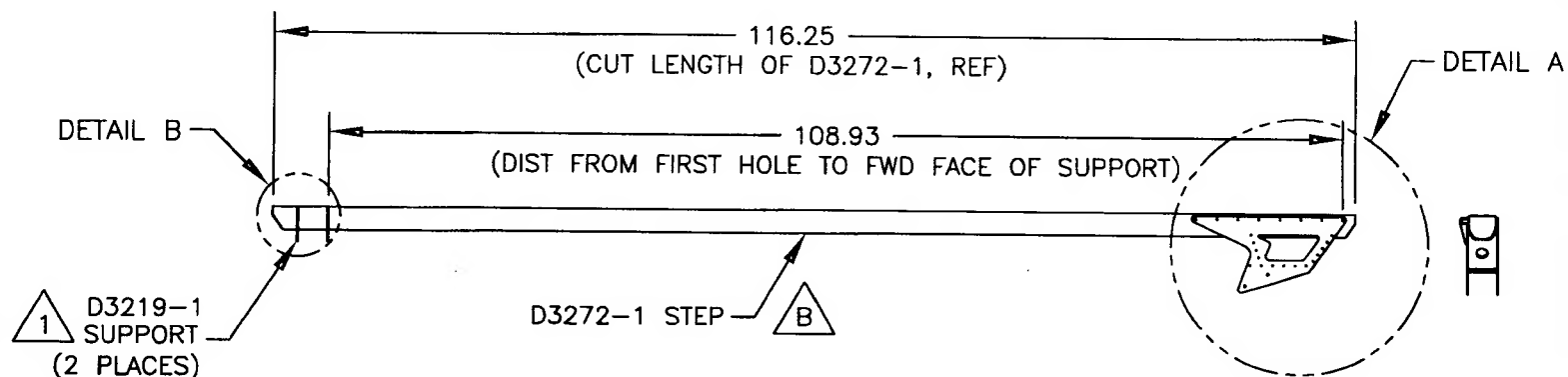
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

12-10-22
91959 MJS
UNCONTROLLED
REVISION
IN PROGRESS
NO. 91959 MJS

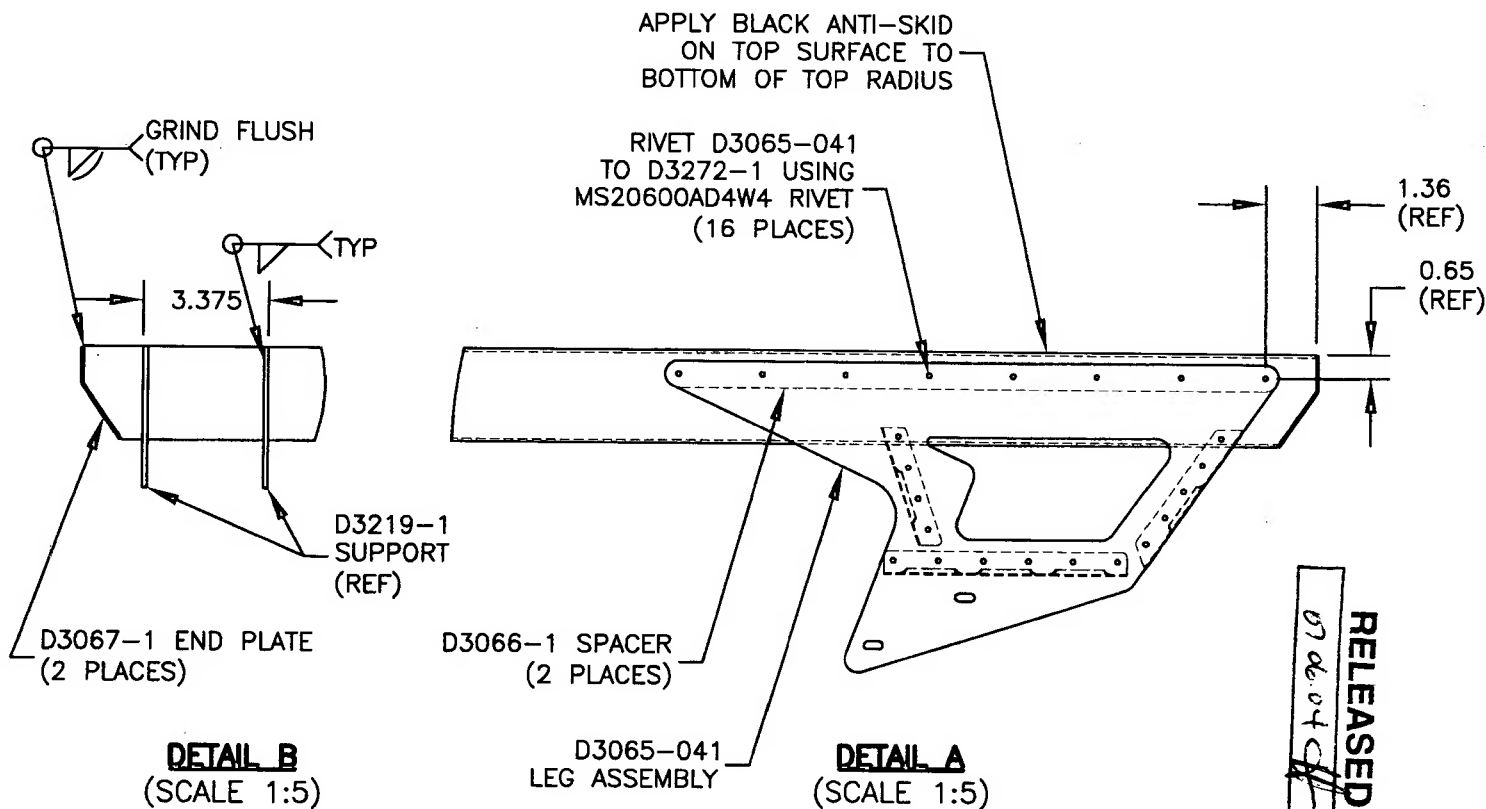
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91959



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

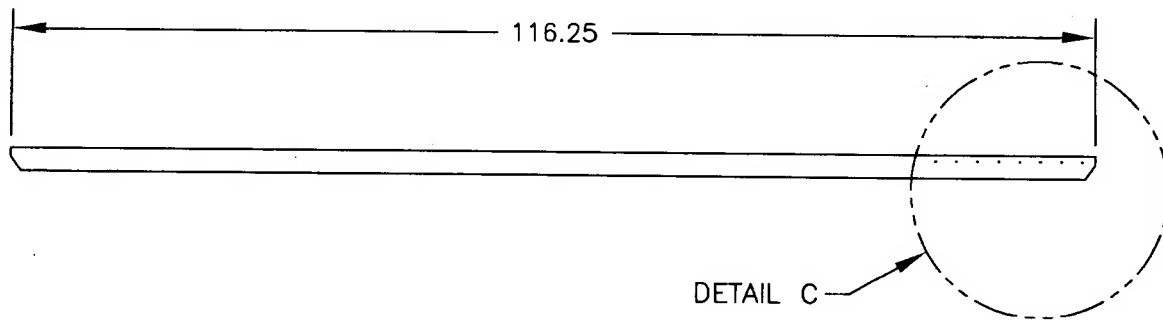


DESIGN 90	DRAWN BY [Signature]	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3272	REV. B
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG	SHEET 2 OF 3	
		SCALE 1:20	

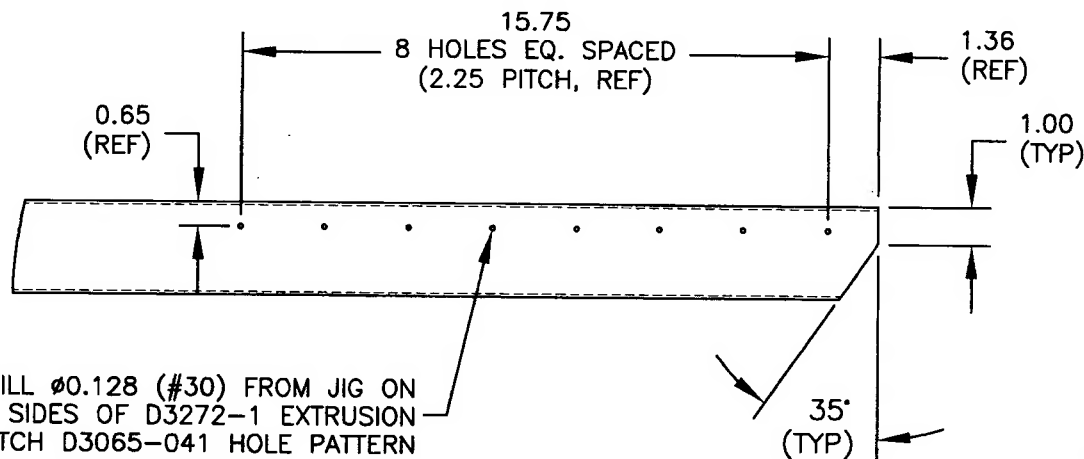
91959

DART

DESIGN	90	DRAWN BY	JS	DART AEROSPACE LTD
CHECKED	CE	APPROVED	JS	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	REV. B
		DRAWING NO.	D3272	SHEET 3 OF 3
		SCALE	1:20	



△ B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

RELEASED
07.06.04